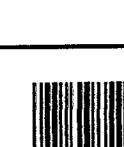


Date: Wednesday, 8/8/2007 9:53:15 AM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: ARM
Job Number	: 33844			
Estimate Number	: 12578			
P.O. Number	:		Part Number	: D3560041
This Issue	: 8/8/2007	S.O. No. :	Drawing Number	: D3560 UNDER REVIEW
Prsht Rev.	: NC		Project Number	: N/A
First Issue	: 8/8/2007	Type : SMALL / MED FAB	Drawing Revision	: B
Previous Run	: 32643		Material	:
Written By	: 07.08.08		Due Date	: 8/15/2007
Checked & Approved By			Qty:	6 Um: Each
Comment	: Est Rev:A New Issue 07.05.24 EC			

Additional Product

Job Number:			
Seq. #:	Machine Or Operation:	Description:	
1.0	D35921	PLATE	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)			
PLATE			
Batch: _____			
2.0	D35601	ARM	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)			
ARM			
Batch: _____			
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
			
Comment: LARGE FABRICATION RESOURCE 1			
1-Weld assembly as per dwg D3560			
4.0	QC5	INSPECT WORK TO CURRENT STEP	
			
Comment: INSPECT WORK TO CURRENT STEP			
5.0	QC9	VISUAL WELDING INSPECTION	
			
Comment: VISUAL WELDING INSPECTION			
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
			
Comment: HAND FINISHING RESOURCE #1			
Chemical Conversion Coat as per QSI 005 4.1			

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 33844

Part Number: D3560041

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0 QC21 FINAL INSPECTION/W/O RELEASE

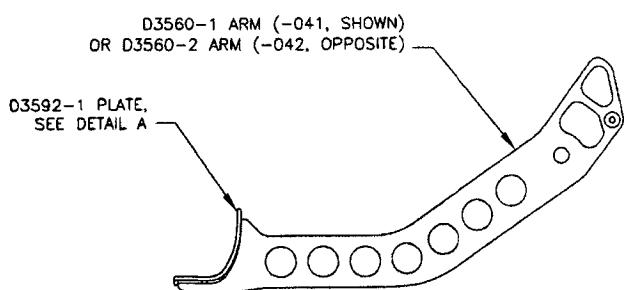


Comment: FINAL INSPECTION/W/O RELEASE

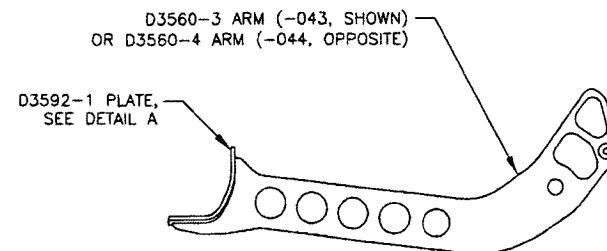
Job Completion



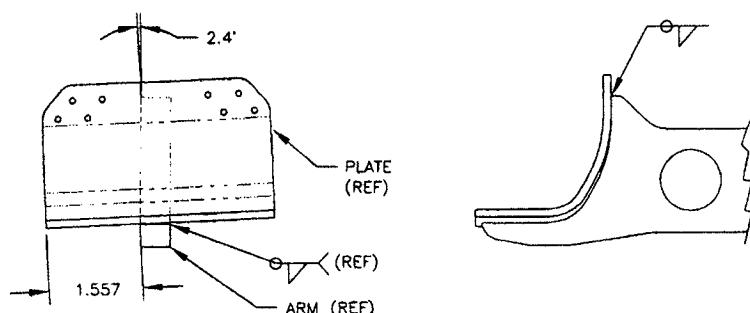
✓



D3560-041 ARM WELDMENT (SHOWN)
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A
(SCALE 1:1)

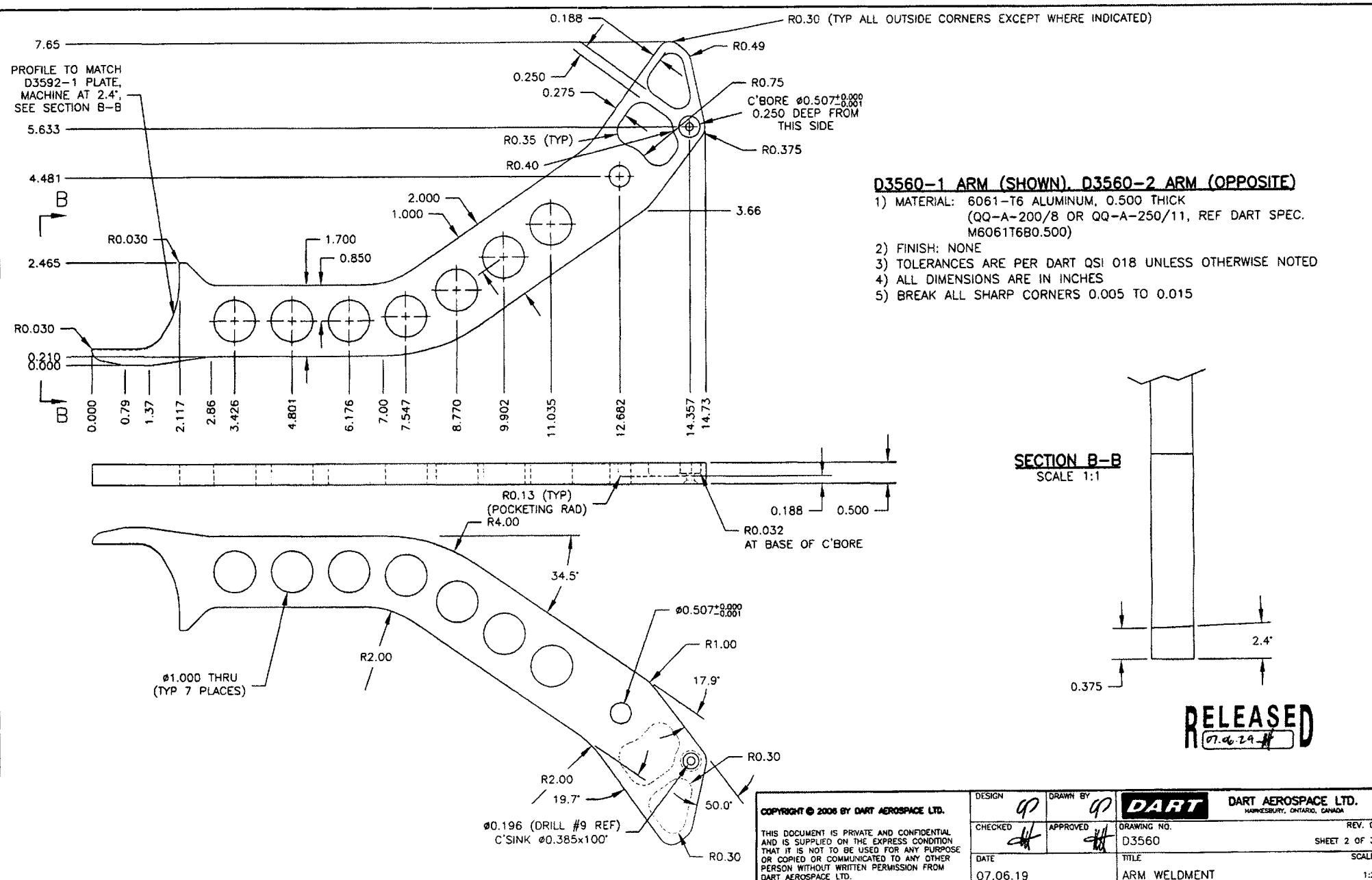
GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED
07.06.19

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CHECKED	APPROVED	DRAWING NO. D3560
DATE	TITLE	REV. C SHEET 1 OF 3
07.06.19	ARM WELMENT	SCALE 1:4



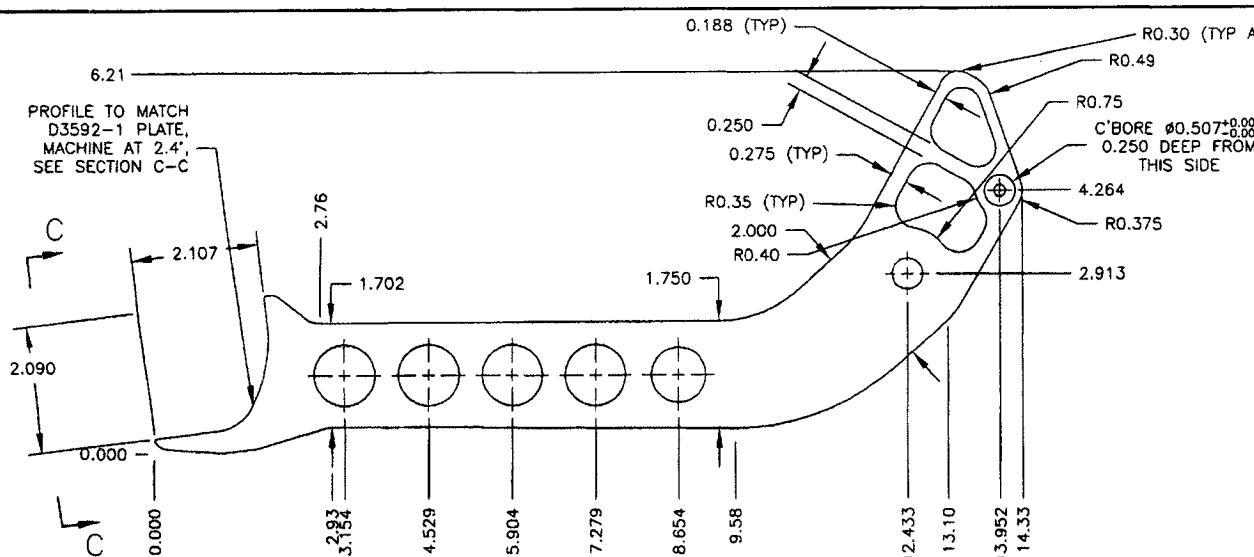
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		3D560	SHEET 2 OF 3
DATE	TITLE		SCALE
07.06.19	ARM WELDMENT		1:1

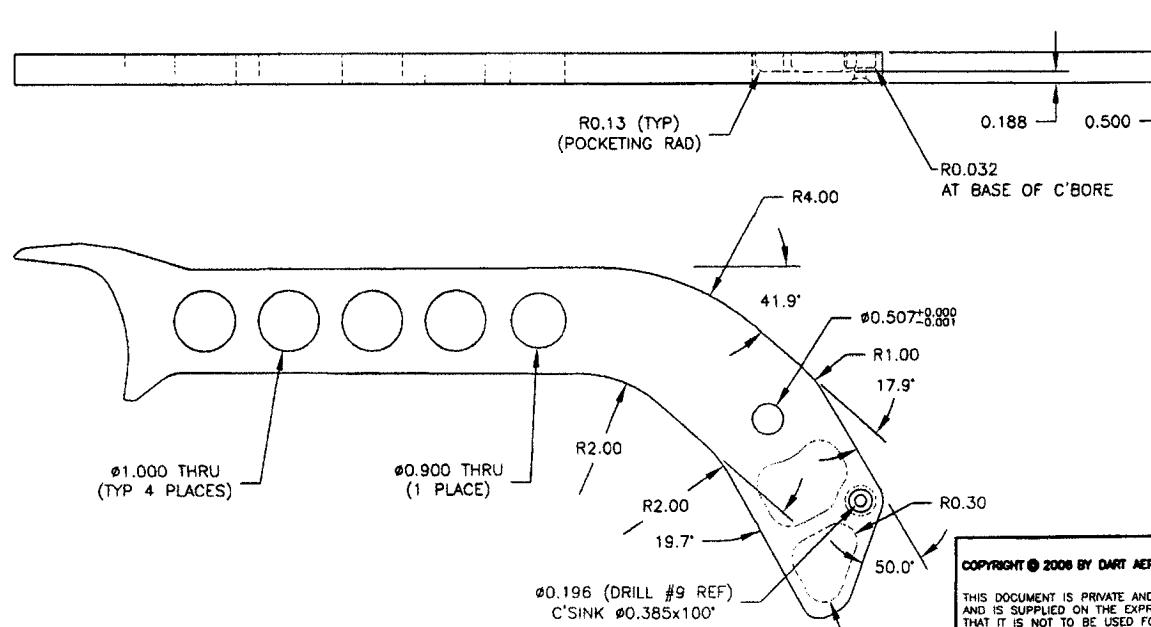
6.21

PROFILE TO MATCH
D3592-1 PLATE,
MACHINE AT 2.4",
SEE SECTION C-C

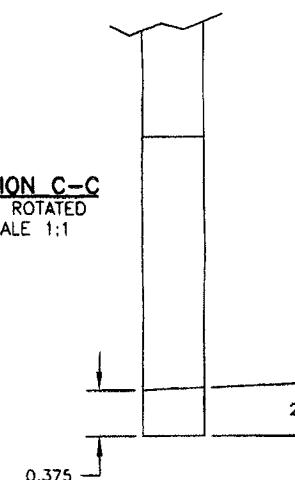


D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC.
M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015



SECTION C-C
VIEW ROTATED
SCALE 1:1



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07	07		REV. C
CHECKED	APPROVED		DRAWING NO. D3560
DATE			SHEET 3 OF 3
07.06.19			SCALE 1:2
			TITLE ARM WELDMENT